



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3537-1

Job Sheet 195544



Part No: D3537-1

Job Qty: 65 pcs

Part Name: Wearpad



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/26/19

Job Tracking No:

Due Date: 5/10/19

Created By: Automated MRP Engine

Type: Stock

Description:

Note: DWG D3537 REV.F IPP Rev:A New Issue 07-02-14 JLM IPP REV:B 15.10.16 added automated welding DD
verf:JLM IPP REV:C 18.11.09 AS PER DWG REV.F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
105	Waterjet - Flow - 1	60 pcs	5/10/19	5/10/19	0.00	2.58	Waterjet - Flow		DAS 69 9-89	7/13/19
125	QC 8	60 pcs	5/10/19	5/10/19	0.00	0.00	QC 8 - 12			
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
							QC 8 - 47			
							QC 8 - 40			
							QC 8 - 52			
							QC 8 - 23			
							QC 8 - 57			
140	Small Fab - Brake NC - B4B	60 pcs	5/10/19	5/10/19	0.03	0.78	Small Fab - Brake - 1 - B4B		DAS 30 9-89	JUL 04 2019
							Small Fab - Brake - 2 - B4B			



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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S195622



Part: D3537-1

Job No: 195544

Serial No/Batch: S195622

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/15/19

				Small Fab - Brake - 3 - B4B	
150	QC 5	60 pcs	5/10/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
160	Automated Welding - B4B	60 pcs	5/10/19	0.00 4.45	Automated Welding - 1 - B4B
170	QC 10	60 pcs	5/10/19	0.00 0.00	QC 10 - 10
					QC 10 - 18
					QC 10 - 24
					QC 10 - 43
					QC 10 - 50
					QC 10 - 58
					QC 10 - 9
180	QC 5	60 pcs	5/10/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
210	Packaging 3-1 - Stock - B4B	60 pcs	5/10/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B

DAS
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9-89

JUL 09 2019

MF

EC

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EC

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220	QC 21 - SA	60 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

JUL 17 2019

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70
9-89

Part Op **105** - 1-Cut D3537-1 as per Dwg D3537 Dwg Rev: F Prog Rev: F 2-Deburr if necessary
 Descriptions: **125** - (QC8- Inspect parts - second check)
140 - (Form as per dwg)
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Automated welding) ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M18901
170 - (QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O)
210 - (Identify as per dwg & Stock Location:)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	6.3600 sf (.106 ea)	105-Waterjet - Flow - 1	5179460

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Waterjet - Flow - 1	M304S16GA	6	295	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	4.250inches $\pm$ 0.010	4.260 4.240	4.251	
2	Wearpad	3.500inches $\pm$ 0.010	3.510 3.490	3.497	
3	Wearpad	1.970inches $\pm$ 0.030	2.000 1.940	1.974	
4	Wearpad	3.630inches $\pm$ 0.030	3.660 3.600	3.625	
5	Wearpad	2.420inches $\pm$ 0.010	2.430 2.410	2.41	
6	Wearpad	0.220inches $\pm$ 0.010	0.230 0.210	0.221	
7	Wearpad	0.375inches $\pm$ 0.010	0.385 0.365	0.377	
8	Wearpad	0.063inches $\pm$ 0.010	0.073 0.053	0.064	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date : _____	Sequence #: _____		QTY Affected : _____		MRB (QSI042)
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
QC / QA Coordinator					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details: _____			



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